



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312GB
Job Sheet 165881



Part No: D350-591-312GB

Job Qty: 1 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black



Part Weight: 0 lbs

Status: Production

Priority: Medium

Job Created: 10/2/17

Job Tracking No:

Due Date: 10/31/17

Created By: Linda Lacelle

Type: Stock

Description:

CHG001

Customer: US Helicopters Inc (CUSHE01)

PO Box 625 Marshville, NC, 28103 USA ph:(704) 233-5000 fx:(704) 233-4255.

Note: DWG REV B

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D350-591-312GB Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black	DWG REV B		0.000	
AN3-35A Bolt			0.000	
AN4-13A Bolt			0.000	
AN5-36A Bolt			0.000	
D2230-3 Mounting Lug	DWG REV G IPP D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED BY:EC		0.000	
D2618 Bushing	DWG REV B1 IPP Rev:F Re-format 05-11-22 JLM		0.000	
D2856-400 Abrasion Strip 4" Wide (Per Foot)	DWG REV A IPP D 02.08.28 Re-format; Added clear & 108 foot roll to Step 2 KJ/RF		0.000	
D3065-041 Step Leg Assembly	DWG REV B IPP Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF		0.000	
D3066-1 Spacer	DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:B Now M6061-T6 06-06-23 JLM		0.000	
D3067-1 End Plate	DWG REV A IPP: 03.01.21 Remove step 6 (Deburr) KJ IPP Rev:B Now on Water jet 06-06-16 JLM		0.000	
D3067-1 End Plate	DWG REV A IPP: 03.01.21 Remove step 6 (Deburr) KJ IPP Rev:B Now on Water jet 06-06-16 JLM		0.000	
D3219-1 Plate	DWG REV B IPP A 04.04.19 New issue KJ/JLM ESR B 06.05.25 Waterjet EC		0.000	
D3235-1 Mounting Lug	DWG REV A IPP A 04.04.19 New issue KJ/JLM		0.000	
D3272-1 Step	DWG REV B IPP Rev:A New Issue 07-06-09 JLM		0.000	
D3278-041 Support Assembly	DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM		0.000	
MS20600-AD4W4 Rivet			0.000	
MS21042L3 Nut	DWG REV A		0.000	
MS21042L4 Nut			0.000	
			0.000	

MS21042L5

Nut

NAS1149D0363J

Washer

0.000

NAS1149D0463J

Washer

0.000

NAS1149D0563J

Washer

0.000

Black

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/31/17	0.00	0.00	Start up container	
180	Large Fab ✓	1 pcs	10/31/17	0.00	0.00	Large Fab 2	0.2894 (3.45)
220	Powdercoat	1 pcs	10/31/17	0.00	0.00	Powdercoat12	BR 17-11-28
230	HandFinish ✓	1 pcs	10/31/17	0.00	0.00	HandFinish3	0.5314 (1.83)
240	QC	1 pcs	10/31/17	0.00	0.00	QC3	
250	Packaging	1 pcs	10/31/17	0.00	0.00	Packaging1	
260	QC	1 pcs	10/31/17	0.00	0.00	QC4	Smb
270	Packaging	1 pcs	10/31/17	0.00	0.00	Packaging3	Smb
280	QC21-FG	1 Ea	10/31/17	0.00	0.00	QC21	12/12/12 FA

Part Op 180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for Descriptions: welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 11:20 OVEN TEMPERATURE: 320° FINISH TIME: 11:50

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

M122878

wing walk 1138373

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	
D350-591-312GB B165881		1 Ea (1 ea)	90-Start up Operation	
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	
D2618	Bushing	2 Ea (2 ea)	250-Packaging	
D2856-400	Abrasion Strip 4" Wide (Per Foot)	1.2000 Ea (1.2 ea)	250-Packaging	
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3272-1	1	0	0	0
	D350-591-312GB B165881	1	1	0	0
180-Large Fab	MS20600-AD4W4	16	0	0	0
250-Packaging	AN3-35A 5017928	2	0	0	0
	AN4-13A 5017923	8	0	0	0
	AN5-36A 5017912	2	0	0	0
	D2230-3 FIC 5498	4	0	0	0
	D2618 5017903	2	0	0	0
	D2856-400-720 FIC 5231X1	1	0	0	0
	D3235-1 5019143	2	0	0	0
	D3278-041 5018923	1	0	0	0
	MS21042L3 5017898	2	0	0	0
	MS21042L4 5017897	8	0	0	0
	MS21042L5 5017893	2	0	0	0

NAS1149D0363J	5017880	4	0	0	0
NAS1149D0463J	3017887	16	0	0	0
NAS1149D0563J	5017884	4	0	0	0

Part Specifications

Specifications could not be found.

Plex 10/2/17 9:09 AM Dart.Renwick.Jennifer

Status: Stock

Part: **D350-591-312GB B16581**

Created: 9/30/17 12:43 PM DART.MICHAUD-
FEBRILLE.VICTORIA **B165881**



Serial No: **S000162**

Printed By: Goldston, Justin 10/2/17 10:45 AM

DART
AEROSPACE
S014366



Heli - Access - Step RH - High Gear, Long Step, Aerazur
Float Compatible - Glossy Black

PART NO: D350-591-312GB

Revision:

Operation: Large Fab

Change No:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 11/27/17

Job No: 165881

Work Order Summary

Thursday, September 28, 2017 10:10:04 AM

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Criteria : Work Order ID: 165881 Item ID: D350-591-312GB Product Family LARGE FAB
 Work Order Start Dates 9/11/2017 to 9/11/2017 11:59:59 PM Work Order Required Dates 9/21/2017 to 9/21/2017 11:59:59 PM
 All References
 Work Order Status Released

Work Order ID	165881	Required Qty	1.0000	Status Code	Released
Item ID	D350-591-312GB	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black				
Current Acct Value	\$290.917				
Start Date	9/11/2017	Required Date	9/21/2017	Completed Date	
Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$12.966	\$0.000	\$0.000	\$0.000	0.00%
Labor	\$137.169	\$0.000	\$91.934	\$91.934	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$309.595	\$0.000	\$198.983	\$198.983	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$459.730	\$0.000	\$290.917	\$290.917	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
D3065-041 Step Leg Assembly	1.0000		9/20/2017	1.0000	\$72.082
D3066-1 Spacer	2.0000		9/20/2017	2.0000	\$8.709
D3067-1 End Plate	2.0000		9/12/2017	2.0000	\$4.277
D3219-1 Plate	2.0000		9/28/2017	2.0000	\$7.022
Total Matl Amts:					\$92.089

Work Center HandFinish

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
LECO02												
		9/19/2017										
140			0.00	0.00	1.57	1.57	1.00	\$0.000	\$34.205	\$85.378	\$0.000	\$119.583
		9/21/2017										
210			0.00	0.00	0.62	0.31	2.00	\$0.000	\$6.761	\$16.876	\$0.000	\$23.638
Total:			0.00	0.00	2.19	1.88	3.00	\$0.000	\$40.966	\$102.255	\$0.000	\$143.220

Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
GAUT02												
		9/12/2017										
110			0.00	0.00	0.49	0.49	1.00	\$0.000	\$10.498	\$21.309	\$0.000	\$31.808
lavi01												
		9/12/2017										
110			0.00	0.00	0.26	0.26	1.00	\$0.000	\$5.631	\$11.429	\$0.000	\$17.060
		9/13/2017										
110			0.00	0.00	0.72	0.72	1.00	\$0.000	\$15.510	\$31.482	\$0.000	\$46.992
lu01												
		9/20/2017										
180			0.00	0.00	0.75	0.75	1.00	\$0.000	\$16.071	\$32.621	\$0.000	\$48.692
		9/21/2017										
180			0.00	0.00	1.23	1.23	1.00	\$0.000	\$26.361	\$53.507	\$0.000	\$79.868
Total:			0.00	0.00	3.45	3.45	5.00	\$0.000	\$74.072	\$150.349	\$0.000	\$224.420

3-Grind End Plate flush $\leftarrow 1^{\text{st}} \text{ Dec } 2017-09-15$

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[illegible]

Work Order ID 165881

Tuesday, September 05, 2017 9:51:32 AM

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Item ID: D350-591-312GB**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black**Start Date:** 9/11/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 9/21/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.01							DAS 24 9-89
Quality Control									
180	Weld per dwg A/R Aluminum rod Batch: _____	0.00							
180	Large Fab								
Large Fab	Memo	0.40							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod <u>M137078</u>								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

x1 SL 2017-9-21

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Item ID: D350-591-312GB Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black
Start Date: 9/11/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/21/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				1	SEP 21 2017		DAS 24 9-89
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				1	SEP 21 2017		DAS 24 9-89
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.10				①	2017-09-21		3030 SL

Work Order ID 165881

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Item ID: D350-591-312GB Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black
Start Date: 9/11/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/21/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* Powdercoat Powder Coating	Gloss Black (Steel) (Ref: QSI005 4.3.5.14) Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.21				_____	_____	_____	_____
230 *230* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch _____ Memo	0.00 0.22				_____	_____	_____	_____
240 *240* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				_____	_____	_____	_____

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Item ID: D350-591-312GB**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black**Start Date:** 9/11/2017 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 9/21/2017 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.01							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.03							
Quality Control									
270	Identify as per dwg & Stock Location: _____	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312 Location :FG072								

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Item ID: D350-591-312GB

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black

Start Date: 9/11/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/21/2017 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

280

QC21- Final Inspection - Work Order Release

0.00

280

0.10

QC

Memo

Quality Control

Picklist Print

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Work Order ID: 165881

165881

Parent Item: D350-591-312GB

D350-591-312GB

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black

Start Date: 9/11/2017

Required Date: 9/21/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D
fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-35A

Purchased

No

250

Each

82.0000

2

2

AN3-35A

Bolt

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

72

M138170

72

AN4-13A

Purchased

No

250

Each

288.0000

8

8

AN4-13A

Bolt

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

9

m135470

9

ST344

259

m138170

59

m138326

200

Picklist Print

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Work Order ID: 165881

165881

Parent Item: D350-591-312GB

D350-591-312GB

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black

Start Date: 9/11/2017

Required Date: 9/21/2017

AN5-36A

Purchased

No

250

Each

Start Qty: 1.00
66.0000 2 2

Required Qty: 1.00

AN5-36A

Bolt

Location

Loc Qty

Loc Code

ST336

66

m137963

50

m138209

16

D2230-3

Manufactured

No

250

Each

252.0000 4 4

D2230-3

Mounting Lug

USE 165998

Location

Loc Qty

Loc Code

FG

4

109344

4

ST521

248

162754

8

163291

80

164011

160

ATTN: GLOSSY BLACK

D2618

Manufactured

No

250

Each

77.0000 2 2

D2618

Bushing

Location

Loc Qty

Loc Code

ST008A

77

163460

27

164495

50

Picklist Print

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Work Order ID: 165881

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Parent Item: D350-591-312GB

D350-591-312GB

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black

Start Date: 9/11/2017

Required Date: 9/21/2017

D2856-400

Manufactured No

250 f

Start Qty: 1.00
94.5810 1.2 1.2

Required Qty: 1.00

D2856-400

Abrasion Strip 4" Wide (Per Foot)

**

Location

Loc Qty

Loc Code

ST418

94.58099526

146265

27.4088853

152590

29.89211

160547

37.28

5/16/2018

cut (2) D2856-400-720 as per dwg

D3065-041

Manufactured No

180 Each

27.0000 1 1

D3065-041

Step Leg Assembly

**

~~2017-09-12~~

Location

Loc Qty

Loc Code

WA002

27

162415

2

164384

1

165204

24

180

Each

54.0000 2 2

D3066-1

Manufactured No

D3066-1

Spacer

**

x1 SL 2017-9-20

~~2017-09-12~~

Location

Loc Qty

Loc Code

WA003

54

159117

4

162500

50

110

Each

20.0000 1 1

D3067-1

Manufactured No

D3067-1

End Plate

**

x2 S.L 2017-9-20

~~2017-09-12~~

Location

Loc Qty

Loc Code

WA003

20

163742

20

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Shop Packet Print

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Picklist Print

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Work Order ID: 165881

165881

Parent Item: D350-591-312GB

D350-591-312GB

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black

Start Date: 9/11/2017

Required Date: 9/21/2017

D3067-1

Manufactured No

180

Each

20.0000

Start Qty: 1.00

Required Qty: 1.00

1

1

D3067-1

End Plate

**

DG 2017-09-12

Location

Loc Qty

Loc Code

WA003

20

B165725 → 1

163742

20

D3219-1

Manufactured No

110

Each

21.0000

2

2

D3219-1

Plate

**

DG 2017-09-12

Location

Loc Qty

Loc Code

WA003

21

B165567 → 2

162382

16

162848

5

D3235-1

Manufactured No

250

Each

73.0000

2

2

D3235-1

Mounting Lug

**

USE 166008

Location

Loc Qty

Loc Code

ST522

73

162757

73

ATTN: GLOSSY BLACK

D3272-1

Manufactured No

110

Each

11.0000

1

1

D3272-1

Step

**

Location

Loc Qty

Loc Code

WA003

11

164356

10

164968

1

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Shop Packet Print

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Picklist Print

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Work Order ID: 165881

165881

Parent Item: D350-591-312GB

D350-591-312GB

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black

Start Date: 9/11/2017

Required Date: 9/21/2017

D3278-041

Manufactured No

250

Each

Start Qty: 1.00
33.0000 1 1

Required Qty: 1.00

D3278-041

Support Assembly

USE 165921

Location

Loc Qty

Loc Code

ST522

33

160701

2

162850

11

164347

20

ATTN: GLOSSY BLACK

MS20600-AD4W4

Purchased No

180

Each

517.0000 16 16

MS20600-AD4W4

Rivet

Location

Loc Qty

Loc Code

ST308

29

M138209

29

WA003

488

M135442

204

M136986

108

M137412

63

M137820

21

M138209

92

Tuesday, September 05, 2017 9:51:32 AM

Shop Packet Print

Page 5

Picklist Print

Tuesday, September 05, 2017 9:51:32 AM

Page 6

Work Order ID: 165881

165881

Parent Item: D350-591-312GB

D350-591-312GB

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black

Start Date: 9/11/2017

Required Date: 9/21/2017

MS21042L3

Purchased

No

250

Each

Start Qty: 1.00
1,805.000 2 2

Required Qty: 1.00

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

72

m135945

72

GA

336

m134360

102

M136665

234

OVER007

500

m138408

500

ST303

897

M126333

16

m138084

2

m138230

500

m138326

379

MS21042L4

Purchased

No

250

Each

2,517.000 8 8

MS21042L4

Nut

Location

Loc Qty

Loc Code

FP001

10

m133363

10

OVER007

1000

m138170

500

m138230

500

ST303

1507

127376

24

m138084

483

m138326

1000

Tuesday, September 05, 2017 9:51:32 AM

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Page 6

Picklist Print

Tuesday, September 05, 2017 9:51:32 AM

Page 7

Work Order ID: 165881

165881

Parent Item: D350-591-312GB

D350-591-312GB

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black

Start Date: 9/11/2017

Required Date: 9/21/2017

MS21042L5

Purchased

No

250

Each

503.0000

Start Qty: 1.00

2

2

Required Qty: 1.00

MS21042L5

Nut

Location

Loc Qty

Loc Code

GA

10

m127813

10

ST303

493

125535

4

m137587

4

m137963

185

m138209

200

m138336

100

NAS1149D0363J

Purchased

No

250

Each

1,379.000

4

4

NAS1149D0363J

Washer

Location

Loc Qty

Loc Code

GA

408

m137963

408

ST263

971

126319

16

m138336

955

Tuesday, September 05, 2017 9:51:32 AM

Shop Packet Print

Page 7

Picklist Print

Tuesday, September 05, 2017 9:51:32 AM

Page 8

Work Order ID: 165881

165881

Parent Item: D350-591-312GB

D350-591-312GB

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible-Glossy Black

Start Date: 9/11/2017

Required Date: 9/21/2017

NAS1149D0463J

Purchased

No

250

Each

Start Qty: 1.00
2,662.000 16 16

Required Qty: 1.00

NAS1149D0463.J

Washer

Location

Loc Qty

Loc Code

GA

547

M135056

40

M137699

507

Return2017

16

M136665

16

ST263

2099

127693

48

M137988

600

M138084

27

M138230

1424

NAS1149D0563J

Purchased

No

250

Each

1,463.000 4 4

NAS1149D0563.J

Washer

Location

Loc Qty

Loc Code

GA

36

m135774

36

ST263

1427

m126319

16

m137820

11

m138040

700

m138209

700

Tuesday, September 05, 2017 9:51:32 AM

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Page 8



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04-11

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165881

ly SEP 07 2017

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



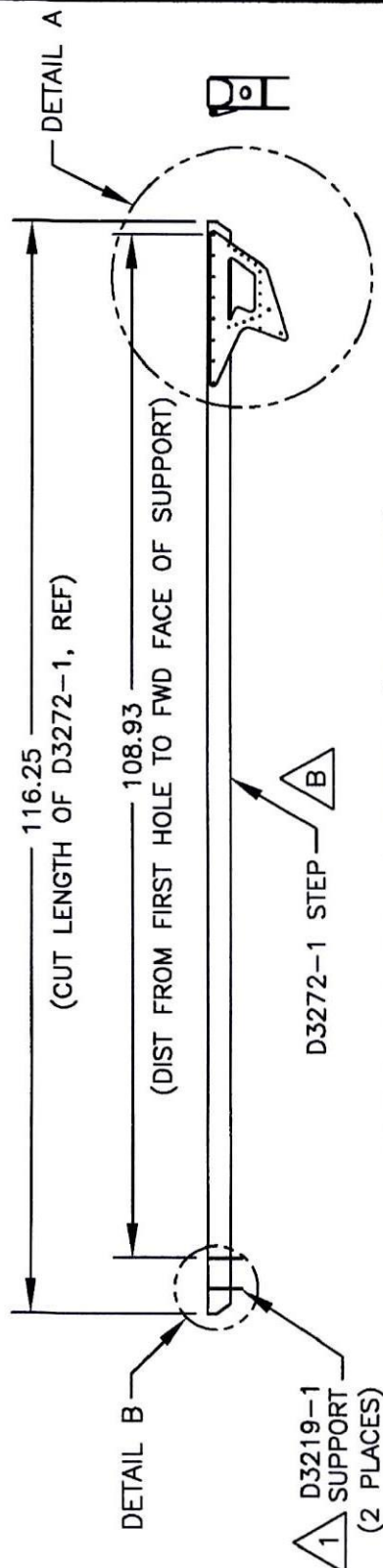
QA Closed: _____ Date: _____

Work Order update only ☐

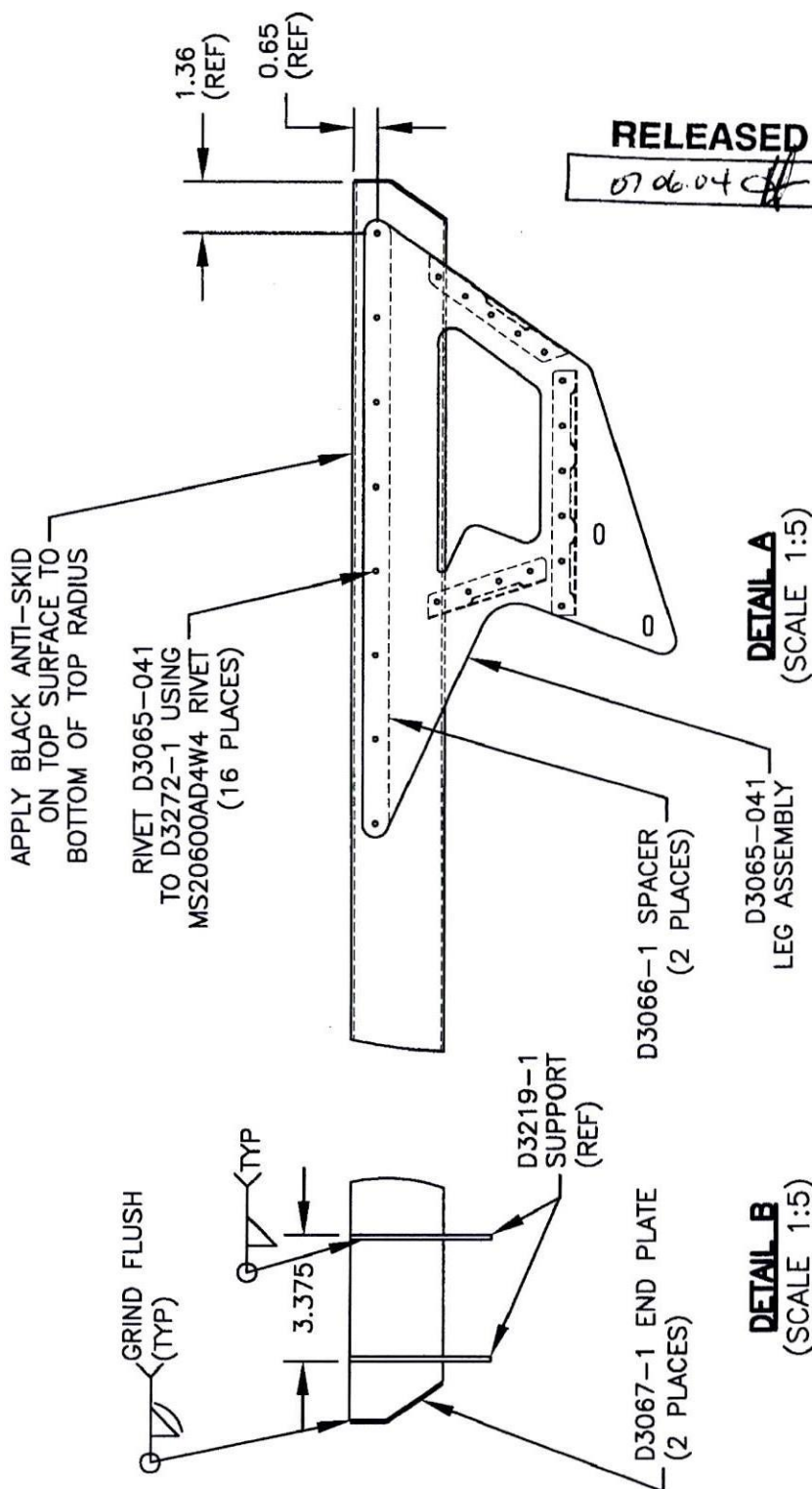
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

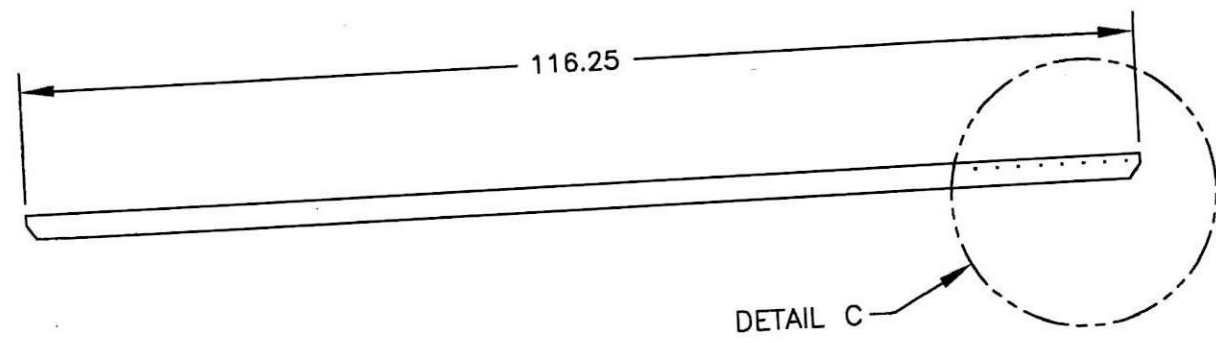
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
☐ OTHER : _____									

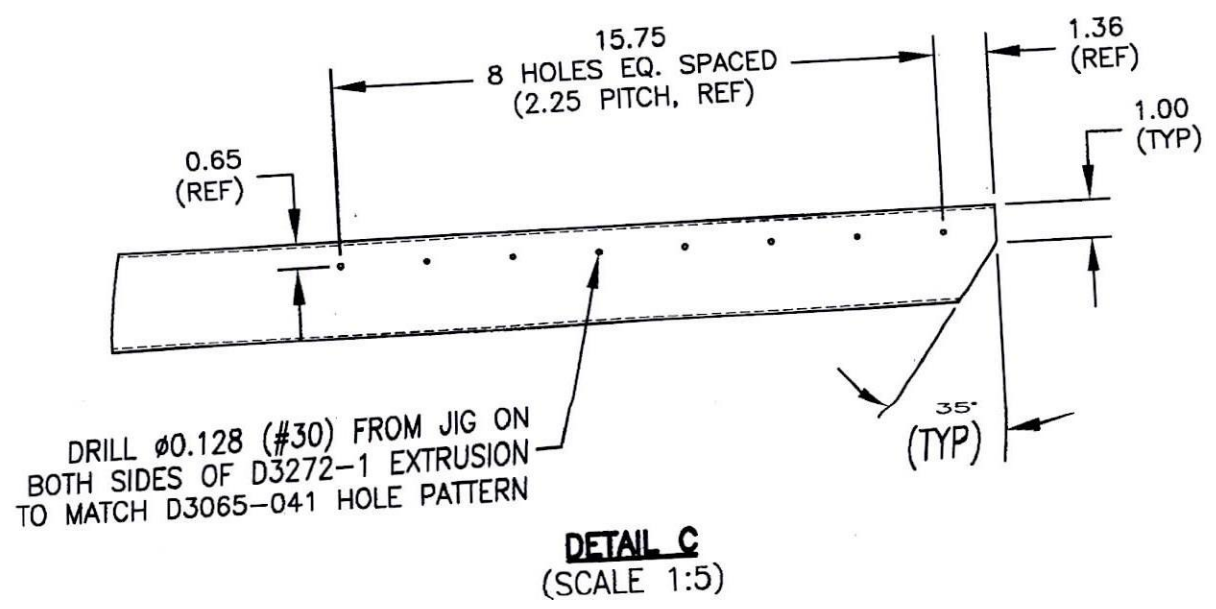


DESIGN	90	DRAWN BY	JR	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	JR	DRAWING NO. D3272
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LOW	SHEET 1 OF 1

RELEASED
07.05.18



△ B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Identified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____									